

Work Order ID 66166

Monday, February 07, 2011 11:31:23 AM

Page 1

Item ID: D2583

Accept

Revision ID:

Item Name: Latch Bracket

Start Date: 2/8/2011 Start Qty: 20.00

Required Date: 2/22/2011 Req'd Qty: 20.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan: MFDate: 11-02-07

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2583

Rev B

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2583 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Debur if necessary

Sosa. 010

B11-017

67

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

B11-017

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

S400217

67

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66166

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Page 2

Item ID: D2583

Accept

Setup Start

Revision ID:

Stop

Item Name: Latch Bracket

Start Date: 2/8/2011 Start Qty: 20.00

Required Date: 2/22/2011 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Debur Form on CNC Brake as per Dwg D2583

0.00

0.00

SB 11/03/01

(27)

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

S 11/03/02

wates

(27)

150



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

0.00

(27) M-L 11/03/02

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Work Order ID 66166

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Page 4

Item ID: D2583

Accept



Setup Start



Revision ID:

Stop



Item Name: Latch Bracket

Start Date: 2/8/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 2/22/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/03

MF

11-03-03

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Picklist Print

Monday, February 07, 2011 11:31:19 AM

Page 1

Work Order ID: 66166



Parent Item: D2583



Parent Item Name: Latch Bracket

Start Date: 2/8/2011

Required Date: 2/22/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP: C□00.11.01□Removed P/O for Powder Coat- in house process□DM□
IPP: D□06.07.21 Waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			100	sf	55.5234	0.1169	2.461053			
5052-H32 .040 Sheet													

LB 11-2-17

Location	Loc Qty	Loc Code
MAT	54.1	
114488	12	
116405	42.1	
MAT23	1.4234	
109058	0.0234	
113123	1.4	

116405

27

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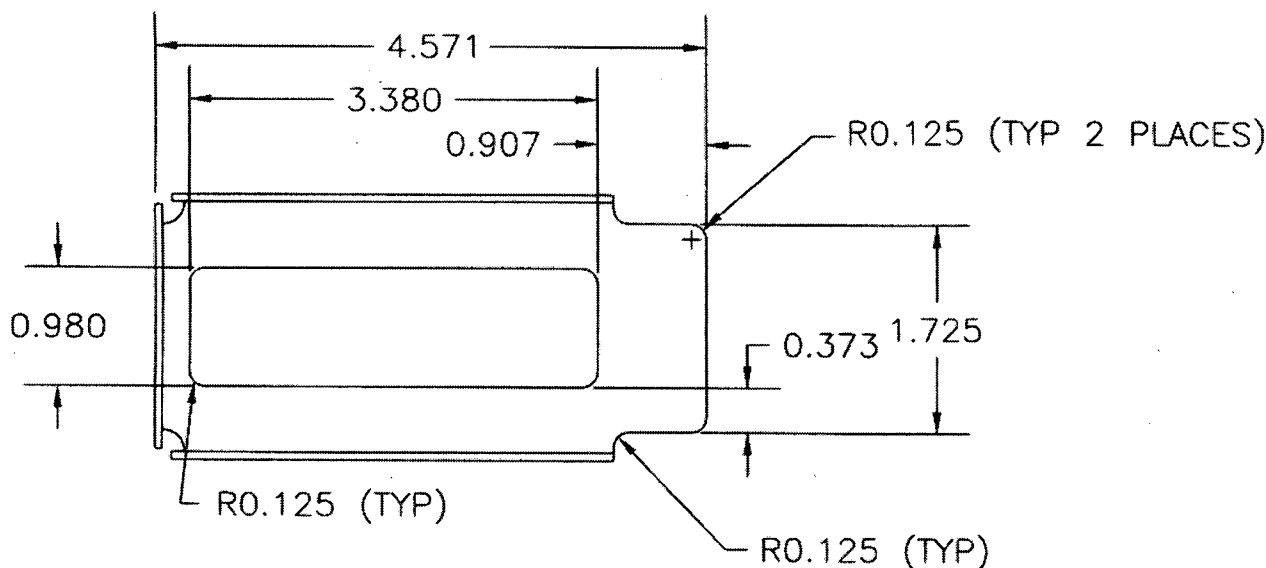
NOTE: Date & initial all entries

DART

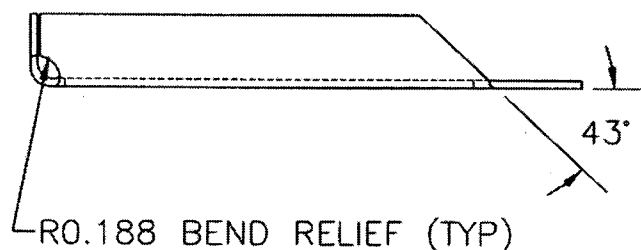
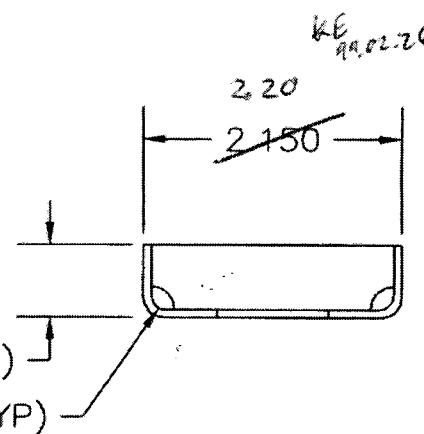


RELEASED
KE 99.02.25

DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
CHECKED	CP	APPROVED	KE	DRAWING NO. D2583
DATE	99.02.22	TITLE	LATCH BRACKET	REV. B
				SHEET 1 OF 1
				SCALE 2:3
A	96.07.10	NEW ISSUE		
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		



66166



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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